

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014930**Date Inspected:** 26-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

**Bay 11**

This QA Inspector randomly observed the following work in progress in Bay 10:

No apparent welding related work was being performed in Bay 11. ZPMC workers were performing match drilling with magnetically mounted drills through previously scored holes into various strut flanges. A template was being used to score the strut flange, then the template was removed and the holes were completed without the template.

**Bay 10**

This QA Inspector randomly observed no apparent welding related work being performed in Bay 10.

**Heavy Dock**

ABF Representative Zhao Ying Sheng informed this QA Inspector that no welding related work was being performed on the heavy dock.

**OBG Trial Assembly Area**

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

FCAW welding of weld joint OBE8A-002 located outside PCMK OBG 8BE/8CE transverse joint, deck plate to deck plate. Welder was identified as 222396. ZPMC QC was identified as ZPMC CWI Liu Hua Jie (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Zhang Xiaoming, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-223(2)1T-2. Also present at this location and appearing to be monitoring the welding operations were ABF Representatives Wang Zhong Yuan and Zhang Xiao Bin.

FCAW welding of weld joint OBE8A-003 located outside PCMK OBG 8BE/8CE transverse joint, deck plate to deck plate. Welder was identified as 220069. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Zhang Xiaoming, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-223(2)1T-2. Also present at this location and appearing to be monitoring the welding operations were ABF Representatives Wang Zhong Yuan and Zhang Xiao Bin.

FCAW welding of weld joint OBE8A-003 located outside PCMK OBG 8BE/8CE transverse joint, deck plate to deck plate. Welder was identified as 220066. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Zhang Xiaoming, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-223(2)1T-2. Also present at this location and appearing to be monitoring the welding operations were ABF Representatives Wang Zhong Yuan and Zhang Xiao Bin.

FCAW welding of weld joint OBE8A-004 located outside PCMK OBG 8BE/8CE transverse joint, deck plate to deck plate. Welder was identified as 220063. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Zhang Xiaoming, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-B-T-223(2)1T-2. Also present at this location and appearing to be monitoring the welding operations were ABF Representatives Wang Zhong Yuan and Zhang Xiao Bin.

FCAW welding of temporary alignment plates located outside PCMK OBG 7DW/7EW transverse joint, deck plate to deck plate. Welders were identified as 045280, 045143. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2132.

SMAW welding of temporary alignment plates located outside PCMK OBG 7DW/7EW transverse joint, bottom plate to bottom plate. Welder was identified as 045268. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-P-2114-FCM-1.

SMAW welding of temporary alignment plates located outside PCMK OBG 7DW/7EW transverse joint, deck plate to deck plate. Welder was identified as 051318. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-P-2114-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

### Summary of Conversations:

As noted above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Goulet, George	Quality Assurance Inspector
----------------------	----------------	-----------------------------

---

<b>Reviewed By:</b>	Dawson, Paul	QA Reviewer
---------------------	--------------	-------------